



Job Sheet 168928

**Ship Via:**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		11/27/17	0.00	0.00	Start Up	Waterjet	SC
100	Waterjet	30 pcs		11/27/17	0.00	0.94	Waterjet1		SC DAS
120	QC	30 pcs		11/27/17	0.00	0.00	QC8		38
130	HandFinish	30 pcs		11/28/17	0.00	0.40	HandFinish1		2017-11-29
140	QC	30 pcs		11/28/17	0.00	0.00	QC7		17-11-29
150	Packaging	30 pcs		11/28/17	0.00	0.00	Packaging3		Stop
160	QC21-SA	30 Ea		11/28/17	0.00	0.00	QC21		

Part Op **100 - 1-Cut as per Dwg D2934**
 Descriptions:

DWS
21
9-89

NOV 29 2017
NOV 30 2017

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.080	1	149	0	0

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S014623



Saddle Spacer

PART NO:
Revision:
Operation:
Change No:

D2934

Start up Operation

Mfg Date: 11/28/17
Job No: 168928

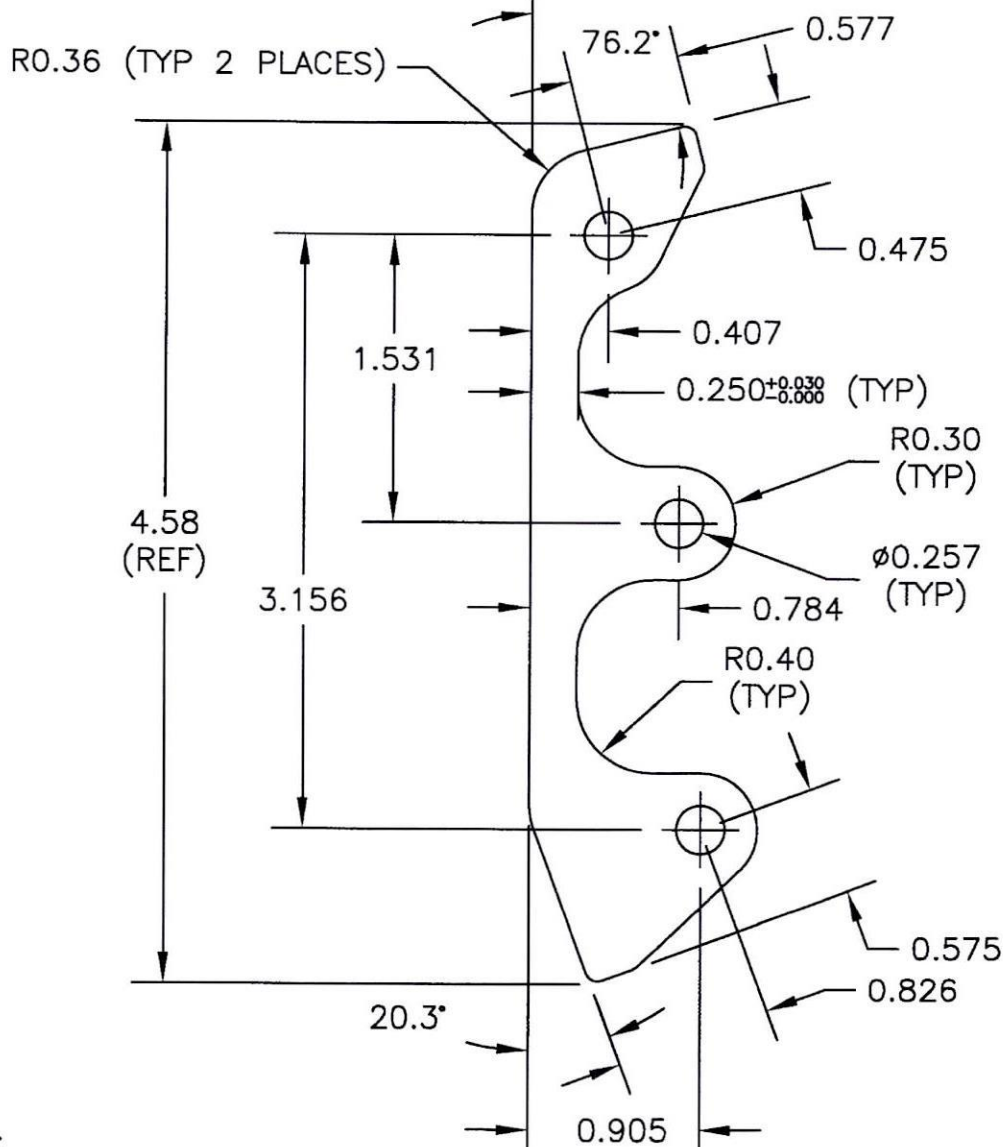
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www.dartaerospace.com

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.475Inches $\pm$ 0.010	0.485 0.465		
2	Saddle Spacer	0.407Inches $\pm$ 0.010	0.417 0.397		
3	Saddle Spacer	0.250Inches + 0.030 - 0.000	0.280 0.250		
4	Saddle Spacer	0.300Inches $\pm$ 0.030	0.330 0.270	Radius	
5	Saddle Spacer	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
6	Saddle Spacer	0.784Inches $\pm$ 0.010	0.794 0.774		
7	Saddle Spacer	0.826Inches $\pm$ 0.010	0.836 0.816		
8	Saddle Spacer	0.360Inches $\pm$ 0.030	0.390 0.330	Radius	
9	Saddle Spacer	0.080Inches $\pm$ 0.010	0.090 0.070		

Plex 11/27/17 7:44 AM dart.lacelle.linda

DART

DESIGN 77	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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